



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4293-1

Job Sheet 184918



Part No: D4293-1

Job Qty: 4 ea

Part Name: Fitting



Part Weight: 0 lbs

Status: New

Priority: High

Job Created: 10/18/18

Job Tracking No:

Due Date: 10/28/18

Created By: Jason Leroux

Type: SOLD

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 10-11-15 JLM VERIFIED BY:DD IPP REV B: AS PER REV B 11-02-15
JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	10/28/18	10/28/18	0.00	0.00	Start Up Machining-2		VHF 10/10/30
100	Bandsaw	4 pcs	10/28/18	10/28/18	0.00	0.40	Bandsaw1		
110	CNC Vertical Machining	4 pcs	10/28/18	10/28/18	0.00	3.64	HAAS 5 Axis		FED 29-10-18
120	QC	4 pcs	10/28/18	10/28/18	0.00	0.00	QC2 Machining-2		FED 29-10-18
130	QC	4 pcs	10/28/18	10/28/18	0.00	0.00	QC8 Machining-2		10/10/30
140	HandFinish	4 pcs	10/28/18	10/28/18	0.00	0.43	HandFinish1		DR 18/10/30
150	Powdercoat	4 pcs	10/28/18	10/28/18	0.00	0.36	Powdercoat1		BR 18-10-31
160	QC	4 pcs	10/28/18	10/28/18	0.00	0.00	QC3		
170	Small Fab	4 pcs	10/28/18	10/28/18	0.00	0.25	Small Fab-6		
180	QC	4 pcs	10/28/18	10/28/18	0.00	0.00	QC5		
190	Packaging	4 pcs	10/28/18	10/28/18	0.00	0.00	Packaging3-2		OCT 31 2018
200	QC21-SA	4 Ea	10/28/18	10/28/18	0.00	0.00	QC21		OCT 31 2018

Part Op 100 - Cut Blank to 6.800" Batch:

GRAIN ALONG 4**

Descriptions: 110 - 1-Machine per folio FB005 DWG REV: FOLIO REV: 2- Deburr and break all sharp edges

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - Chemical Conversion Coat per QSI005 4.1

150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum MASK THREADED HOLE

160 - QC3- Inspect Part Finish

170 - INSTAL HELICOIL AS PER DWG

180 - QC5- Inspect part completeness to step on W/O

190 - Identify as per dwg & Stock Location:

200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T73B4.000x4.000	7075-T73 Bar 4.0 X 4.0 Grain Direction Along 4"	2.2800 ft (.57 ea)	90-Start up Operation	
MS21209F1-10	Heli Coil	4 Ea (1 ea)	170-Small Fab	

5043346 x6
5044218 4x
5120516 2x
billets

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T73B4.000x4.000	2	27	0
170-Small Fab	MS21209F1-10	4	20	0

Part Specifications

Specifications could not be found.

**Container No: S122606****Part: D4293 - 1****Job No: 184918****Serial No/Batch: S122606****Revision:****Inspector:****Exp Date:****Instructions: Various STC's**

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CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/30/18

Plex 10/18/18 8:58 AM dart.leroux.jason

DART AEROSPACE LTD		Work Order:	
Description: Fitting		Part Number:	D4293-1
Inspection Dwg: D4293 Rev: C		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.305	+0.030/-0.010	0.303	✓		Vernier	VHJ01
R0.063	+/-0.010	R0.063	✓		RG	
0.125	+0.030/-0.010	0.133	✓		Vernier	
0.88	+/-0.030	0.884	✓			
0.500	+/-0.010	0.500	✓			
0.82	+/-0.030	0.820	✓			
0.39	+/-0.030	0.394	✓			
0.088	+/-0.010	0.088	✓		Depth gage	VHJ01
0.625	+/-0.010	0.617	✓		Vernier	
1.730	+/-0.010	1.730	✓			
0.800	+/-0.010	0.795	✓			
0.275	+/-0.010	0.280	✓			
1.13	+/-0.030	1.124	✓			
3.11	+/-0.030	3.117	✓			
3.44	+/-0.030	3.440	✓			
2.450	+/-0.010	2.450	✓			
1.325	+/-0.010	1.327	✓			
0.305	+/-0.010	0.303	✓			
2.84	+/-0.030	2.836	✓			
5.86	+/-0.030	5.866	✓			
6.52	+/-0.030	6.525	✓			
0.19	+/-0.030	0.190	✓			
Ø0.272	+0.006/-0.001	0.272	✓			
Ø0.323	+0.006/-0.001	0.323	✓			
1.75	+/-0.030	1.755	✓			
R0.25	+/-0.030	R0.25	✓		RG	
4.875	+/-0.010	4.874	✓			
0.493	+/-0.010	0.489	✓			
Ø0.201	+0.005/-0.001					
0.800 deep	+/-0.010					
CSK Ø0.320 x 100°	+/-0.010					
0.663	+/-0.010					
C-bore Ø0.765	+/-0.010	0.765	✓			
6.20	+/-0.030	6.220	✓			
R0.13	+/-0.030	R0.130	✓		RG	
1.125	+/-0.010					
Ø0.381	+0.000/-0.001					

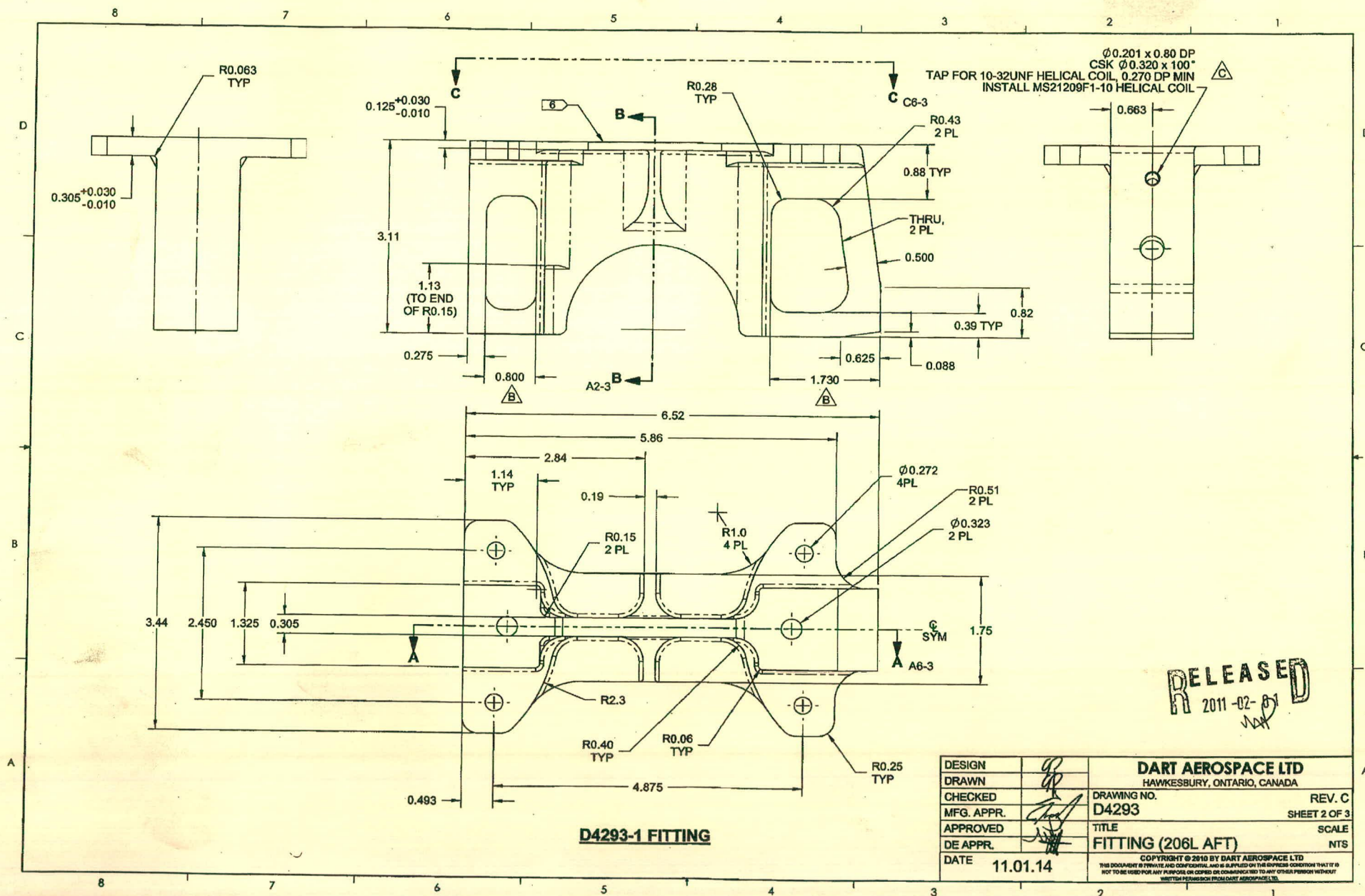
DART AEROSPACE LTD		Work Order:	
Description: Fitting		Part Number:	D4293-1
Inspection Dwg: D4293 Rev: C		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.388	+/-0.010					
R0.031	+/-0.010	R0.032	✓		RG	
4.500	+/-0.010	4.496	✓		Vernier	
R1.370	+/-0.010	R1.360	✓		height gage	3100G
2.250	+/-0.010	2.245	✓		Vernier	
0.680	+/-0.010	0.6795	✓		↓	
1.65	+/-0.030	1.660	✓		↓	
1.42	+/-0.030	1.42	✓		↓	

Measured by: <i>VHS / W18/10/25</i>	Audited by: <i>manL</i>	Preliminary Approval:	
Date: <i>18/10/25</i>	Date: <i>18/10/30</i>	Date:	

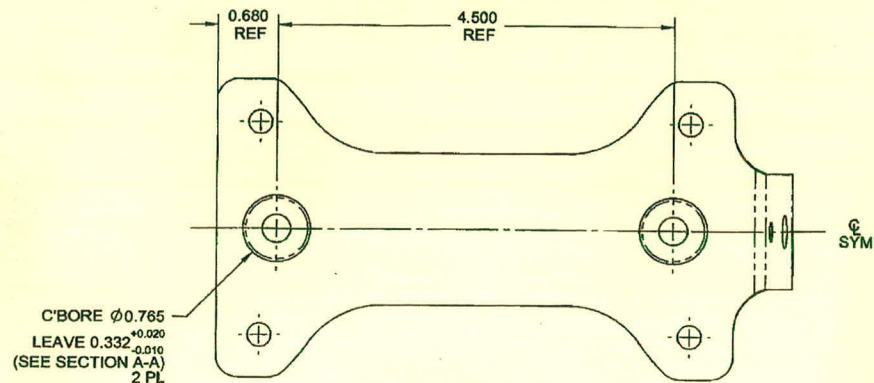
Rev	Date	Change	Revised by	Approved
A	11.07.26	New Issue	KJ	<i>[Signature]</i>



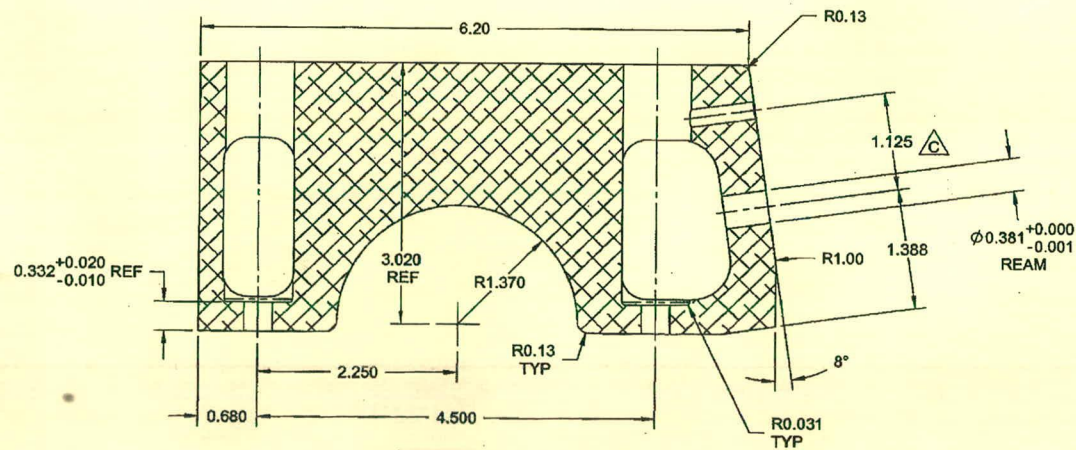
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2011-02-01

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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4293	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FITTING (206L AFT)	NTS
DATE	11.01.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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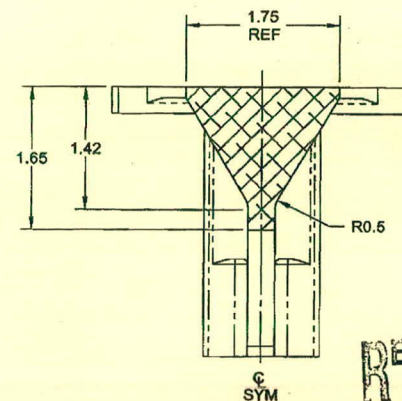
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SECTION C-C D3-2



SECTION A-A A3-2

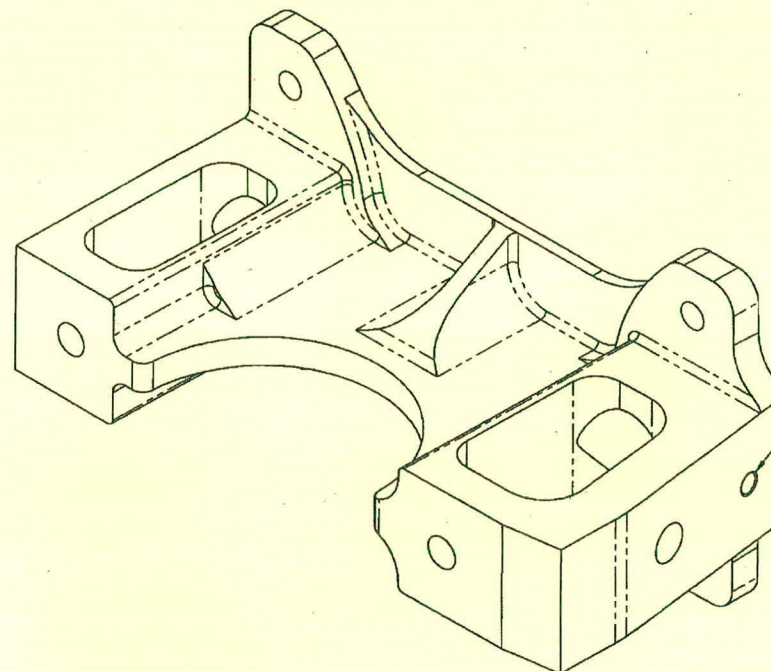


SECTION B-B C5-2

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MFG. APPR.		TITLE	SHEET 3 OF 3
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8 7 6 5 4 3 2 1



MS21209F1-10 HELICAL COIL, 1X
REF

GRAIN
DIRECTION

D4293-1 FITTING

NOTES:

- 1) MATERIAL: 7075-T73/-T7351/-T73510/-T73511 BAR
PER AMS-QQ-A-200/11 OR AMS-QQ-A-225/9 (AMS 4124) OR AMS-QQ-A-250/12 (AMS 4078)
REF DART SPEC. M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D4293-1" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 1.18 lbs

RELEASED
2011-02-01
Handwritten signature

C	ADD HELICAL COIL (D1-2, B4-3)	CP	11.01.14
B	0.800 WAS 0.78 (C8-2), 1.730 WAS 1.72 (C4-2)	CP	10.11.30
A	NEW ISSUE	CP	10.11.09
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4293 REV. C SHEET 1 OF 3 TITLE FITTING (206L AFT) NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
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